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Method of Manufacturing Glass Optical Elements

[0001]

[Field of the Invention]

The present invention relates to a method of manufacturing glass optical elements for molding with high surface precision lenses, for example, in which one or both surfaces are concave and have a ratio b/a of the peripheral thickness b to the center thickness a of at least 1.5.

[0002]

[Background of the Invention]

Methods in which softened glass is pressed with a mold having the shape of the product or similar to that of the product to directly manufacture lenses without grinding or polishing (precision pressing methods) are widely utilized. Precision pressing is employed to manufacture the optical system lenses of a variety of optical equipment and products such as digital cameras and video cameras. In precision pressing, the molding surface of the mold must be transferred to the glass as precisely as possible.

[0003]

However, in lenses in which one or both surfaces are concave, even though molding surfaces are transferred to the glass, the glass sometimes moves back in the direction of one of the surfaces while solidifying, or a transferred surface that has been molded deteriorates, sometimes precluding adequate surface precision. This tendency is marked in the molding of lenses with a ratio b/a of the peripheral thickness b to the center thickness a of at least 1.5.

[0004]

[Summary of the Invention]

Accordingly, an object of the present invention is to provide a method of manufacturing glass optical elements permitting the molding of lenses that are concave on one or both surfaces with high surface precision.

[0005]

Research conducted by the present inventors resulted in the discovery that the above-stated problem was solved, in the case of a lens with one concave surface, by delaying cooling of the concave surface relative to cooling of the surface (flat or convex) on the opposite side, and in the case of lenses with two concave surfaces, by delaying cooling of the concave surface with the smaller radius of curvature relative to cooling of the concave surface on the opposite side with the larger radius of curvature.

[0006]

The present invention relates to a method for manufacturing a glass optical element having at least one concave surface, comprising the steps of:

softening a glass molding material by heating,

molding the softened material with a first mold having a first molding surface and a second mold having a second molding surface by applying a pressure, the first molding surface comprising a first concave surface, the second molding surface comprising a convex surface, planar surface or second concave surface, the second concave surface having a curvature radius greater than that of said first concave surface,

whereby shapes of the first molding surface and the second molding surface are transferred to the material,

cooling the material so that a temperature of the material reaches a temperature equal to or lower than glass transition temperature (T_g), and

removing the cooled material from either of said first mold or said second mold,

wherein in the cooling step, a second temperature of said second mold reaches the glass transition temperature prior to a time when a first temperature of said first mold reaches the glass transition temperature.

[0007]

In a preferred embodiment of the present invention, one of either the first mold or the second mold comprises an upper mold, and the other comprises a lower mold; and said first mold preferably comprises an upper

mold and said second mold preferably comprises a lower mold; and when the second temperature reaches the glass transition temperature, the first temperature is preferably at least 5 degree centigrade higher than the glass transition temperature.

[0008]

One of the embodiments of the present manufacturing method (Manufacturing Method 1) is that for glass optical elements, in which one optically functional surface is concave, comprising steps of :

softening a glass molding material by heating

press-molding the heat-softened glass molding material with a forming mold comprising an upper mold and a lower mold with molding surfaces for forming the optically functional surfaces of the glass optical element to be molded, one of these molding surfaces being concave and the other being convex or flat, thereby transferring shapes of the molding surfaces to the glass material being molded;

cooling the forming mold to cool the molded glass to a temperature equal to or lower than the glass transition temperature (T_g) of the glass; and

removing the cooled glass from the forming mold;

wherein the cooling is conducted such that the temperature ta_2 of the mold with the convex or flat molding surface reaches T_g before the temperature ta_1 of the mold with the concave molding surface.

[0009]

The second embodiment of the present manufacturing method (Manufacturing Method 2) is that for glass optical elements in which both optically functional surfaces are concave, comprising steps of:

softening a glass molding material by heating

press-molding the heat-softened glass molding material with a forming mold comprising an upper mold and a lower mold with molding surfaces for forming the optically functional surfaces of the glass optical element to be molded, both of these molding surfaces being concave, thereby transferring

shapes of the molding surfaces to the glass material being molded;

cooling the forming mold to cool the molded glass to a temperature equal to or lower than the glass transition temperature (T_g) of the glass; and

removing the cooled glass from the forming mold;

wherein the cooling is conducted such that the temperature tb_2 of the mold with molding surface having the larger radius of curvature reaches T_g before the temperature tb_1 of the mold with the molding surface having the smaller radius of curvature.

[0010]

[Brief Description of the Drawings]

Fig. 1 shows glass optical elements (A), (B), and (C) that are manufactured by the method of the present invention.

Fig. 2 is a drawing descriptive of a concave meniscus lens in which a flat portion perpendicular to the optical axis is provided on the outside of the optically functional surface.

Fig. 3 shows typical changes over time in the temperatures of the two molds (upper mold, lower mold) in the manufacturing method of the present invention.

Fig. 4 is a schematic diagram of the molding device employed in Examples 1-3 and Comparative Examples 1 and 2.

Fig. 5 is a descriptive drawing of the glass lens manufactured in Example 1.

Fig. 6 is a descriptive drawing of the glass lens manufactured in Example 2.

Fig. 7 is a descriptive drawing of the glass lens manufactured in Example 3.

Fig. 8 shows change over time in the temperature of the upper mold (concave surface), temperature of the lower mold (convex surface), and pressure applied in Example 1.

Fig. 9 shows change over time in the temperature of the upper mold

(concave surface), temperature of the lower mold (convex surface), and pressure applied in Example 2.

Fig. 10 shows change over time in the temperature of the upper mold (concave surface), temperature of the lower mold (convex surface), and pressure applied in Example 3.

Fig. 11 shows change over time in the temperature of the upper mold (concave surface), temperature of the lower mold (convex surface), and pressure applied in Comparative Example 1.

Fig. 12 shows change over time in the temperature of the upper mold (concave surface), temperature of the lower mold (convex surface), and pressure applied in Comparative Example 2.

Fig. 13 shows the degree of surface precision of the glass lenses obtained in Examples 1-3 and Comparative Examples 1 and 2.

[0011]

The present invention is described in detail below.

The glass optical element that is manufactured in the manufacturing method of the present invention may be, for example, a lens with one or two concave surfaces. Specifically, the manufacturing method of the present invention is suited to lenses in which the ratio b/a of the peripheral thickness b to the center thickness a is 1.5 or greater.

[0012]

Fig. 1 shows an example of such a lens. In the lens 10 shown in Fig. 1(A), one surface S2 is concave and the other surface S1 is flat. In the lens 11 shown in Fig. 1(B), one surface S2 is concave and the other surface S1 is convex. In the lens 12 shown in Fig. 1(C), both surfaces S1 and S2 are concave. However, the concave radius of curvature R of surface S1 is larger than the concave radius of curvature R of surface S2. In lenses (A) to (C), the ratio b/a , the ratio of the peripheral thickness b to the center thickness a can be made not less than 1.5.

[0013]

The concave meniscus lens and double-concave lens that are manufactured by the method of the present invention have optically functional surfaces (optically effective regions) for incorporation into various lens systems. In Fig. 2, for example, the concave surface denoted by 41 is such a surface. In an actual lens, a flat portion 43 perpendicular to the optical axis is provided on the outside of concave surface 41.

[0014]

In lenses in which one or both surfaces are concave, lessening distortion in the cooling step following press-molding causes deformation in a direction reducing the radius of curvature of the concave surface in lenses in which one surface is concave, and deformation in a direction reducing the radius of curvature of the concave surface with the smaller radius of curvature in lenses in which both surfaces are concave. This is particularly marked in lenses in which the ratio of b/a is 1.5 or greater. However, the same tendency exists even in the molding of lenses in which ratio b/a is less than 1.5; the manufacturing method of the present invention is also effective and advantageous for lenses in which ratio b/a is less than 1.5. Further, although the manufacturing method of the present invention is effective in lenses in which the ratio b/a is 1.5 or greater, the ratio b/a in lenses that are actually employed is up to about 3.5. However, the manufacturing method of the present invention may be employed in the molding of lenses with even higher b/a ratios.

[0015]

In Manufacturing Method 1 of the present invention, as shown in Fig. 1(A) and (B), one of the surfaces of the lens is either flat or convex. In this case, cooling during the cooling step is conducted so that the temperature ta_2 of the mold with a convex or flat molding surface reaches the glass transition temperature T_g of the glass being molded before temperature ta_1 of the mold with a concave molding surface. Preferably, the cooling conditions are set so that temperature ta_1 is at least 5 degree centigrade higher than temperature ta_2 .

when temperature ta2 reaches Tg. In particular, the cooling conditions are set so that temperature ta1 is preferably 5 to 40, more preferably 5 to 30, still more preferably 5 to 20 degree centigrade higher than temperature ta2 when temperature ta2 reaches Tg.

[0016]

Further, temperature ta2 is lower than temperature ta1 at least at the end of the molding step, and more preferably, temperature ta2 is at least 5 degree centigrade lower than temperature ta1 at the end of the molding step. That is, the temperatures of the forming mold at the end of pressure application are set so that temperature ta2 of the mold for forming a flat or convex surface (S1) is at least 5 degree centigrade lower than temperature ta1 of the mold for forming a concave surface (S2) ($ta1 - ta2 \geq 5$ degree centigrade).

In particular, temperature ta2 is preferably lower than temperature ta1 from the beginning to the end of the molding step.

[0017]

Manufacturing Method 2 of the present invention is directed to the case where both surfaces are concave, as shown in Fig. 1(C). In that case, temperature tb2 of the mold having the forming surface with the larger radius of curvature reaches Tg before temperature tb1 of the mold having the forming surface with the smaller radius of curvature. More preferably, the cooling conditions are set so that tb1 is at least 5 degree centigrade higher than temperature tb2 when temperature tb2 reaches Tg. In particular, the cooling conditions are set so that temperature tb1 is preferably 5 to 40, more preferably 5 to 30, still more preferably 5 to 20 degree centigrade higher than temperature ta2 when temperature tb2 reaches Tg.

[0018]

Temperature tb2 is preferably lower than temperature tb1 at least at the end of the molding step, and more preferably, temperature tb2 is at least 5 degree centigrade lower than temperature tb1, at least at the end of the molding step. That is, the temperature of the forming mold at the end of pressure

application is set so that temperature $tb1$ of the mold for forming the concave surface (S1) with the smaller radius of curvature R is at least 5 degree centigrade higher than temperature $tb2$ of the mold for forming the concave surface (S2) with the larger radius of curvature R ($tb1 - tb2 \geq 5$ degree centigrade).

In particular, temperature $tb2$ is preferably lower than temperature $tb1$ from the beginning to the end of the molding step.

[0019]

Embodiments of the method of manufacturing glass optical elements of the present invention comprises (1) a molding step in which a heat-softened glass molding material is press-molded by a forming mold comprising an upper mold and a lower mold with molding surfaces forming the optically functional surfaces of the glass optical element to be molded, one of these molding surfaces being concave and the other being convex or flat in Manufacturing Method 1, and both of these molding surfaces being concave in Manufacturing Method 2, thereby transferring shapes of the molding surfaces to the glass material being molded; (2) a cooling step in which the forming mold is cooled to cool the molded glass to below the glass transition temperature (T_g) of the glass; and (3) a removal step in which the cooled glass is removed from the forming mold.

[0020]

The press-molding of a glass optical element (for example, a glass lens) is characterized by the use of a forming mold comprising an upper mold and a lower mold with molding surfaces for forming the optically functional surfaces of the glass optical element, and in that a prescribed difference in temperature is imparted between the upper mold and the lower mold by a prescribed time of the press-molding and cooling steps; known methods may be employed without alteration for the other steps and conditions. In the precision pressing of molding a glass article, a glass lens material such as a glass preform or a glass gob is supplied to a forming mold having an upper

mold and a lower mold with opposing molding surfaces corresponding to the shape of the lens; press-molding is performed at prescribed pressure and for a prescribed time; both the forming mold and the molded product are cooled either at the start of press-molding, part way through press-molding, or at the end of press-molding; and after cooling to a prescribed temperature, the molded product is removed from the forming mold. The temperature conditions of the glass lens material and forming mold when the glass lens material is supplied to the forming mold and during press-molding can be suitably determined in view of the lens material, shape, dimensions, and the like.

[0021]

In the present invention, the temperature of the forming mold is preferably adjusted so that $t_1 - t_2 \geq 5$ degree centigrade at the end of the initial application of pressure. In forming mold having t_1 and t_2 , these temperatures may correspond to either the upper mold or the lower mold, respectively. However, to facilitate molding and centering of the glass material on a mold, when molding a lens, one of the surfaces of which is flat or convex, the mold forming the flat or convex surface (S1) is desirably the lower mold, and the mold forming the concave surface (S2) is desirably the upper mold. Further, when molding a lens, both surfaces of which are concave, the mold forming the concave surface (S1) with the larger radius of curvature R is desirably the lower mold and the mold forming the concave surface (S2) with the smaller radius of curvature R is the upper mold.

[0022]

In the preferred embodiments of the present invention, the difference in temperature ($t_1 - t_2$) between the upper and lower molds is set to be 5 degree centigrade, at least at the end of the initial application of pressure. Here, the term "initial application of pressure" means the application of pressure used to mold the glass lens material into the shape corresponding to the molding surfaces of the forming mold. In the manufacturing method of the present

invention, pressure (for example, the weight of the upper mold itself) may be further applied to the molded product after the initial application of pressure, or the molded product may be cooled without applying pressure after the initial application of pressure. However, pressure such as pressure resulting from the weight of the upper mold itself is preferably continuously applied to the molded product until the glass is removed from the mold.

[0023]

The difference in temperature for example, ($t_1 - t_2 \geq 5$ degree centigrade) in the upper and lower two molds may be applied from the start of pressure application for molding, for example. Specifically, the upper mold and the lower mold are heated under different heating conditions. This state is shown in Fig. 3(A). In the figure, (1) is the start of press-molding and (2) is the end of the initial application of pressure. In Fig. 3(A), the condition ($t_1 - t_2 \geq 5$ degree centigrade) is already satisfied at the start of press-molding (1). Even when the condition ($t_1 - t_2 \geq 5$ degree centigrade) is not satisfied at the start of pressure application for molding, the temperature of the forming mold can be controlled during pressure application for molding so that satisfying ($t_1 - t_2 \geq 5$ degree centigrade). In that case, for example, the mold of temperature t_2 could be aggressively cooled to achieve ($t_1 - t_2 \geq 5$ degree centigrade) during the application of pressure for molding. Fig. 3(B) shows that state. In this figure, as well, (1) denotes the start of press-molding and (2) denotes the end of the initial application of pressure. In Fig. 3(B), at the start of press-molding (1), the temperature difference satisfies $t_1 - t_2 < 5$ degree centigrade and then the mold of temperature t_2 is aggressively cooled so that ($t_1 - t_2 \geq 5$ degree centigrade) is satisfied at the end of the initial application of pressure (2). In Fig. 3(B), the temperature difference can be $t_1 = t_2$ at point (1) and then temperature adjustment can be made to satisfy ($t_1 - t_2 \geq 5$ degree centigrade) at the end of initial application of pressure (2).

[0024]

In one of the preferred embodiments, so long as the temperature

difference (t_1-t_2) between the upper and lower molds is at least 5 degree centigrade at the end of the initial application of pressure, glass optical elements (for example, lenses) can be obtained with little distortion and good surface precision. In that case, the temperature difference (t_1-t_2) in the two molds preferably falls within the range of from 10-20 degree centigrade at least at the end of the initial application of pressure.

[0025]

In the method of the present invention, from the perspective of reducing nonuniformity in glass contraction resulting from the cooling step following application of pressure and from the perspective of reducing the amount of distortion, desirable is cooling in such a manner that the temperature difference (t_1-t_2) between the two molds becomes at least 5 degree centigrade before the temperature of the mold forming the flat or convex surface, or the mold forming the concave surface with the larger radius of curvature R , reaches T_g .

[0026]

The initial application of pressure in the molding step of the manufacturing method of the present invention can be conducted at 294×10^4 - $3,432 \times 10^4$ Pa for a period of 30-300 sec. Further, in the cooling step, secondary pressure application can be conducted (a secondary application of pressure being desirable), with the secondary application of pressure being conducted at 196×10^4 - $2,450 \times 10^4$ Pa for a period of, for example, 30-300 sec. The pressure applied in the secondary application is preferably smaller than that in the initial application. Secondary pressure application is desirably conducted immediately following initial pressure application, and is preferably conducted until the glass temperature reaches a temperature about 50°C lower than the T_g of the glass. Further, in the manufacturing method of the present invention, in the period following secondary pressure application through when the molded glass is removed from the mold, a final pressure application can be conducted at 0.0098×10^4 - 4.9×10^4 Pa.

[0027]

[Examples]

The present invention is described in detail below through Examples.

The molding device shown in Fig. 4 was employed in Examples 1-3 and Comparative Examples 1 and 2 below. In the molding device shown in Fig. 4, an upper mold 22 and a lower mold 23 are disposed within a hot molding chamber 21 sealed within a housing 21a. Upper mold 22 and lower mold 23 are secured through adiabatic bases 29 and 30 to the front ends of upper fixed shaft 24 and lower movable shaft 25, respectively. Lower movable shaft 25 is linked to a pressure cylinder, not shown, by which it is driven upward during pressure application.

In each of the Examples and comparative examples, an initial pressure of 588×10^4 Pa was applied for 2 min and a secondary pressure of 294×10^4 Pa was applied for 3 min.

Further, adiabatic bases 29 and 30 have cooling gas outlets 31 and 32, respectively, for independently cooling upper mold 22 and lower mold 23. The supply of gas can be independently controlled above and below, permitting change in the cooling rates of upper mold 22 and lower mold 23. An inert gas was employed as the cooling gas.

[0028]

Example 1

The glass lens (ratio $b/a=2.9$, concave meniscus) of the shape shown in Fig. 5, one surface of which was concave (radius of curvature $R=4$ mm) and the other side of which was convex (radius of curvature $R=50$ mm) was manufactured. The concave surface was formed with the upper mold and the convex surface with the lower mold. NbFD13 ($T_g=535$ degree centigrade, $T_s=570$ degree centigrade) was employed as the glass material. The molding conditions are given in Table 1.

[0029]

The upper mold (concave surface) temperature, lower mold (convex

surface) temperature, and various changes in pressure applied over time are shown in Fig. 8. The temperature (ta1) of the upper mold (concave surface) was 610 degree centigrade and the temperature (ta2) of the lower mold (convex surface) was 590 degree centigrade at the start of press-molding, with a difference in temperature between the two being 20 degree centigrade. During press-molding, these temperatures were maintained; the temperature (ta1) of the upper mold (concave surface) was also 610 degree centigrade and the temperature (ta2) of the lower mold (convex surface) was also 590 degree centigrade at the end of the initial application of pressure, with a difference in temperature between the two of 20 degree centigrade. Cooling progressed, and the temperature (ta1) of the upper mold (concave surface) when the temperature (ta2) of the lower mold (convex surface) reached the glass material Tg of 535 degree centigrade was 545 degree centigrade, with a difference in temperature between the two of 10 degree centigrade. Further, the difference between temperature (ta2) of the lower mold (convex surface) and temperature (ta1) of the upper mold (concave surface) at the end of second pressure application was 4 degree centigrade.

[0030]

Example 2

The glass lens (ratio $b/a=2.5$, concave meniscus lens) of the shape shown in Fig. 6, one surface of which was concave (radius of curvature $R=17$ mm) and the other surface of which was convex (radius of curvature $R=23$ mm) was manufactured. The concave surface was formed with the upper mold and the convex surface with the lower mold. LaC13 ($T_g=520$ degree centigrade, $T_s=560$ degree centigrade) was employed as the glass material. The molding conditions are given in Table 1.

[0031]

The temperature of the upper mold (concave surface), the temperature of the lower mold (convex surface), and the various changes in pressure applied over time are given in Fig. 9. The temperature (ta1) of the upper

mold (concave surface) was 600 degree centigrade and the temperature (ta2) of the lower mold (convex surface) was 580 degree centigrade at the start of press-molding, with a difference in temperature between the two of 20 degree centigrade. During press-molding, the temperature (ta1) of the upper mold (concave surface) was gradually decreased. The temperature (ta1) of the upper mold (concave surface) was 590 degree centigrade and the temperature (ta2) of the lower mold (convex surface) was 580 degree centigrade, with a difference in temperature between the two of 10°C, at the end of the initial application of pressure. Cooling progressed, and the temperature (ta1) of the upper mold (concave surface) when the temperature (ta2) of the lower mold (convex surface) reached the glass material Tg of 520 degree centigrade was 528 degree centigrade, with a difference in temperature between the two of 8 degree centigrade. Further, the difference between temperature (ta2) of the lower mold (convex surface) and temperature (ta1) of the upper mold (concave surface) at the end of second pressure application was 1 degree centigrade.

[0032]

Example 3

The glass lens (ratio $b/a=3.0$, double-concave lens) of the shape shown in Fig. 7, one surface of which was concave (radius of curvature $R=38$ mm) and the other surface of which was also concave (radius of curvature $R=180$ mm) was manufactured. The concave surface with the smaller R was formed with the upper mold and the concave surface with the greater R was formed with the lower mold. LaC13 ($T_g=520$ degree centigrade, $T_s=560$ degree centigrade) was employed as the glass material. The molding conditions are given in Table 1.

[0033]

The temperature of the upper mold (lower R concave surface), the temperature of the lower mold (higher R concave surface), and the various changes in pressure applied over time are given in Fig. 10. The temperature (tb1) of the upper mold (lower R concave surface) was 600 degree centigrade

and the temperature (tb2) of the lower mold (higher R concave surface) was 580 degree centigrade at the start of press-molding, with a difference in temperature between the two of 20 degree centigrade. During press-molding, the temperature (tb1) of the upper mold (lower R concave surface) was gradually decreased. The temperature (tb1) of the upper mold (lower R concave surface) was 595 degree centigrade and the temperature (tb2) of the lower mold (higher R concave surface) was 580 degree centigrade, with a difference in temperature between the two of 15 degree centigrade, at the end of the initial application of pressure. Cooling progressed, and the temperature (tb1) of the upper mold (lower R concave surface) when the temperature (tb2) of the lower mold (higher R concave surface) reached the glass material Tg of 520 degree centigrade was 530 degree centigrade, with a difference in temperature between the two of 10 degree centigrade. Further, the difference between temperature (tb2) of the lower mold (higher R concave surface) and temperature (tb1) of the upper mold (lower R concave surface) at the end of second pressure application was 2 degree centigrade.

[0034]

Comparative Example 1

With the exception that the temperatures of the upper and lower molds given in Table 1 were made identical, a glass lens was formed in the same manner as in Example 1. The temperature of the upper mold (concave surface), lower mold (convex surface), and various changes in pressure applied over time are given in Fig. 11.

[0035]

The temperature (ta1) of the upper mold (concave surface) was 600 degree centigrade and the temperature (ta2) of the lower mold (convex surface) was also 600 degree centigrade at the start of press-molding, with the difference in temperature between the two being 0 degree centigrade. During press-molding, these temperatures were maintained; the temperature (ta1) of the upper mold (concave surface) was also 600 degree centigrade and the

temperature (ta2) of the lower mold (convex surface) was also 600 degree centigrade at the end of the initial application of pressure, with a difference in temperature between the two of 0 degree centigrade. Cooling progressed, and the temperature (ta1) of the upper mold (concave surface) when the temperature (ta2) of the lower mold (convex surface) reached the glass material Tg of 535 degree centigrade was 535 degree centigrade, with a difference in temperature between the two of 0 degree centigrade. Further, the difference between temperature (ta2) of the lower mold (convex surface) and temperature (ta1) of the upper mold (concave surface) at the end of second pressure application was 0 degree centigrade.

[0036]

Comparative Example 2

With the exception that the temperature of the upper mold (concave surface) was made lower than the temperature of the lower mold (convex surface) as shown in Table 1, a glass lens was molded in the same manner as in Example 1. The upper mold (concave surface) temperature, lower mold (convex surface) temperature, and various changes in pressure applied over time are shown in Fig. 12. The temperature (ta1) of the upper mold (concave surface) was 595 degree centigrade and the temperature (ta2) of the lower mold (convex surface) was 605 degree centigrade at the start of press-molding, with the difference in temperature between the two being -10 degree centigrade. During press-molding, the temperature (ta1) of the upper mold (concave surface) was gradually increased. The temperature (ta1) of the upper mold (concave surface) was 600 degree centigrade and the temperature (ta2) of the lower mold (convex surface) was 605 degree centigrade at the end of the initial application of pressure, with a difference in temperature between the two of -5 degree centigrade. Cooling progressed, and the temperature (ta1) of the upper mold (concave surface) when the temperature (ta2) of the lower mold (convex surface) reached the glass material Tg of 535 degree centigrade was 533 degree centigrade, with a difference in temperature between the two of -2.

(ta1) of the upper mold (concave surface) when the temperature (ta2) of the lower mold (convex surface) reached the glass material Tg of 535 degree centigrade was 533 degree centigrade, with a difference in temperature between the two of -2. Further, the difference between temperature (ta2) of the lower mold (convex surface) and temperature (ta1) of the upper mold (concave surface) at the end of second pressure application was 0 degree centigrade.

[0037]

The degrees of surface precision of the glass lenses of Examples 1-3 and Comparative Examples 1 and 2 are given in Fig. 13. An evaluation of "good" in the degree of surface precision of Table 1 means that no "astigma or irregularity" were seen in an interference pattern within the effective diameter (optical effective diameter: about 80 percent of the region projected in the interference pattern comprises the effective diameter).

[0038]

Table 1

	At the start of press-molding			At the end of the initial application			At Tg	Surface precision
	t1	t2	Δt	t1	t2	Δt	Δt	
Temp(°C)								
Ex.1	610	590	20	610	590	20	10°C	Good
Ex.2	600	580	20	590	580	10	8°C	Good
Ex.3	600	580	20	595	580	15	10°C	Good
C.Ex.1	600	600	0	600	600	0	0°C	Bad
C.Ex.2	595	605	-10	600	605	-5	-2°C	Bad

[0039]

As shown in Table 1, increasing the upper mold (concave surface) temperature above the lower mold (convex surface) temperature so that temperature ta2 of the mold with a forming surface that was convex or flat

[illegible]

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